

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58535

May 10, 2010 12:37:30 PM



Page 2

Item ID:	D2939-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle RH In, 206					
Start Date:	10/05/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	14/05/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00	ark 10/05/24			4	0		
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00	JH 10/05/25			4	0		
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00	M 114207						
Powder Coating									
	START TIME: 9:00AM		OVEN TEMPERATURE:						
	FINISH TIME: 9:30PM		320°F						

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Item ID:	D2939-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle RH In, 206				Stop	
Start Date:	10/05/2010	Start Qty:	4.00			
Required Date:	14/05/2010	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location: <u>Y28A</u>	0.00							
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10-5-25

10-5-25

10/05/26

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Picklist Print

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Page 1

Work Order ID: 58535



Parent Item: D2939-2



Parent Item Name: Saddle RH In, 206

Start Date: 10/05/2010

Required Date: 14/05/2010

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC
IPP Rev: C As per Rev C 07-03-19 JLM ☐ ☐

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	82.0000	1			



Saddle Billet



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	40	
46409	40	
MAT40	42	
46409	42	

21

MU
10/05/24

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DART AEROSPACE LTD		Work Order: 28535
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	.125	.120	.123	
B	0.100	0.140		.125	.125	.118	.125	
C	0.100	0.140		.103	.104	.104	.100	
D	0.210	0.230		.220	.225	.216	.225	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.512	.512	.512	.512	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.259	.259	.259	.259	
L	0.312	0.317		.315	.315	.315	.315	
M	0.235	0.240		.235	.237	.237	.236	
N	0.100	0.140		.110	.111	.110	.111	
O	0.540	0.560		.554	.555	.554	.554	
P	0.490	0.510		.500	.500	.500	.500	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.740	2.740	2.740	2.740	
S	0.240	0.270		.250	.251	.253	.251	
T	0.100	0.180		.135	.135	.135	.135	
U	1.625	1.635		1.628	1.628	1.629	1.629	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.317	.317	.317	.317	
X	1.250	1.270		1.266	1.265	1.265	1.26	
Y	1.565	1.585		1.580	1.579	1.577	1.576	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: MUE	Date: 10/05/24
Audited by: CMK	Date: 10/05/24
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

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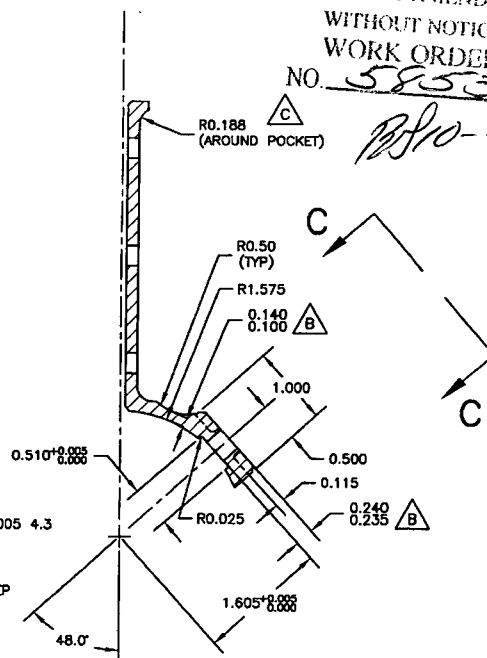
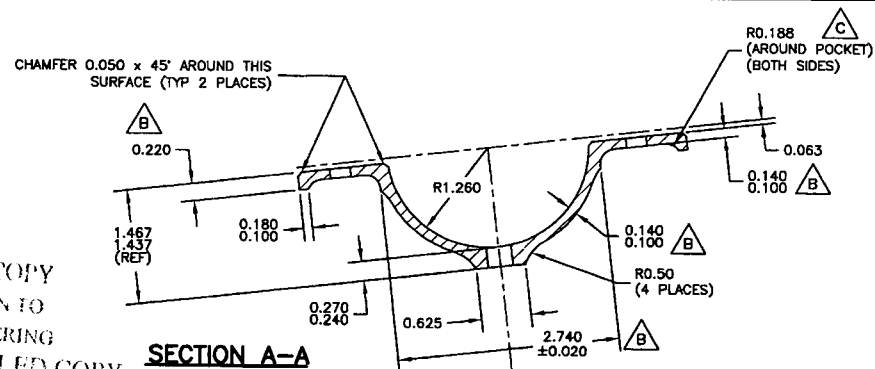
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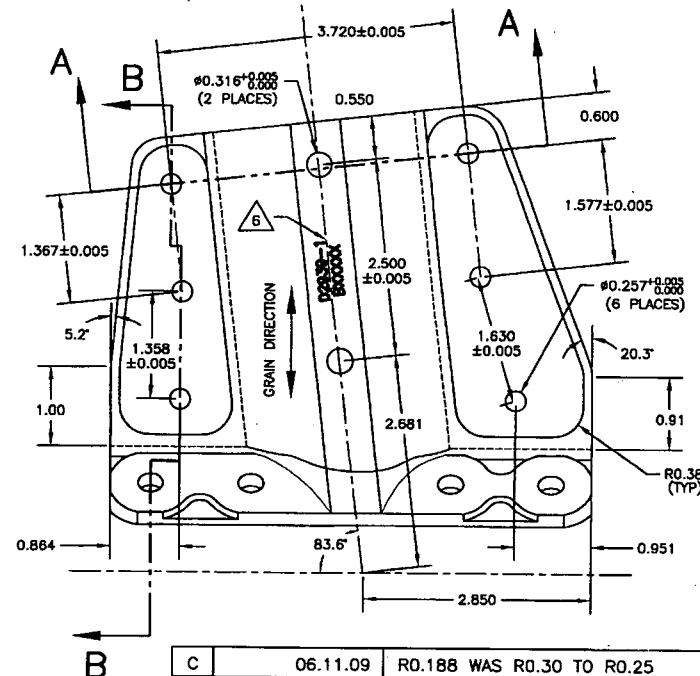
NOTE: Date & initial all entries



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55535



SECTION B-B



- NOTES:** 0.510"
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER PART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER PART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER PART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.20 TO R0.25	
B	00.05.29	CHANGED DEOMETRY AND MATERIAL	
A	99.11.12	NEW ISSUE	
DESIGN	# DRAWN BY CB	DART DART AEROSPACE USA, INC. BELLVILLE, TX	
CHECKED	APPROVED PH UK	DRAWING NO. D2939	REV. 0
DATE	06.11.09	TITLE	SHEET 1 OF 1
		SADDLE INSIDE	SCALE

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.

DRAWING NO.
D2939

TITLE	SADDLE INSIDE
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REV. C
T 1 OF :

SCALE
2:1

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